Tuesday, 11/29/2005 7:14:45 PM

Linda Lacelle

**Process Sheet** 

: CU-DAR001 Dart Helicopters Services

Job Number

: 25048A : 10731

P.O. Number

: NA : 11/29/2005

: NIA

: 24528A

S.O. No. : NA

· SMALL /MED FAB

Part Number **Drawing Number** 

**Due Date** 

**Drawing Name** 

: D23243 D2324 REV. C

: STOP

: N/A

Project Number : C **Drawing Revision** Material

: NIA

: 12/6/2005

20 Um:

Qtv:

Each

Written By

**Checked & Approved By** 

E 03.02.28

Reformat; Incorporated D2324-3 & D2324-5 K

J/RF

**Additional Product** 



Seq. #:

Description:

M6061T6B0750X00750 1.0

6061-T6 Bar .75" x .75"

Comment: Qty.:

0.5565 f(s)/Unit Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch:

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: (0,75" x 0.75") x 5.75" Long Bar

20

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Machine as per Folio D2324-3 and Dwg D2324
- 2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

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4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5-12-12

5.0

SECOND CHECK



Comment: SECOND CHECK



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Page 1

Form: rprocess

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W/O:			WORK ORDER CHANGES			
DATE	STEP		PROCEDURE CHANGE By Date	Qtý	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	 NCR: Yes No DQA:	Date: 05/12/16
				.r
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC	Initial	Corrective Action Section B	Sign &	Verification	Approval	Approval		
	* .	Section A	<b>Initial</b> Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector		
05/12/12	3	- 1 part cut too short did not machine completely	07143		J.L	18-12-12	OFFIN			
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NOTE: Date & initial all entries

	iesday, 11/29/2005 7:14:46 PM inda Lacelle	Process Sheet		
Custome	r: CU-DAR001 Dart Helicopters Servi	Drawing Name: STOP		
Job Numbe	r: 25048A	Part Number: D23243	3	
Job Number:				
Seq.#:	Machine Or Operation:	Description	n:	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
Comm	ment: HAND FINISHING RESOURC		FF 05/12/15	Ź
7.0	Acid etch and Alodine as per	INSPECT POWDER COAT/CHEMICAL		
				2
Comr 8.0	ment: INSPECT ALODINE PACKAGING 1	PACKAGING RESOURCE #1	SB OR WILL	7
8.0	PACKAGING I	, Tronvente nestation		
Com	ment: PACKAGING RESOURCE #1		SB 00/12/15	22
9.0	Location: GA	DOCUMENT CONTROL	33 20712 118	
Com	ment: DOCUMENT CONTROL Inspection Level 21	NE 05/12/16 (20)	D OSLIZIO	(Si
Job Completion				
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Page 2

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W/O:		•		WORK ORDER CHANGI	ES	•			
DATE	STEP	1:		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	<b>)</b> :	E .	PAR #:	Fault Category:	NCR: Yes	No DQ	Δ.	Date:	

Part No:	r 	PAR #:	Fault Category:	NCR: Yes	No DQA:	Date: _	•
•		100		QA: N/	C Closed:	Date: _	
NCR:		: : : : : : : : : : : : : : : : : : :	WORK ORDER NON-CON	FORMANCE (NCR)			
	- 1	Description of NC	Corrective Action	n Section B	Verification	Approval	Annroyal
DATE STI	EP	Section A	Initial Action Desc	cription Sign &	Section C	Approval Chief Eng	Approval QC Inspector

:			Description of NC			Cor	rective Action	Section B		Verification	Annrousi	Annroyal	
DATE	STEP	STEP		Section A	1.	Initial Chief Eng	1:-	Action Description	on Sig	n & ate	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	.258				
Ø0.191	+/-0.010	.193				
0.750	+/-0.010	.750				
0.375	+/-0.010	.37/	1			
1.875	+/-0.010	1.872	1			
5.250	+/-0.010	5.245				
5.625	+/-0.010	5.621				
			,			
				13		
			4			

Measured by:	J.L	Audited by:	NS	Prototype Approval:	N/A
Date:	05.12.12	Date:	05/12/12	Date:	N/A .

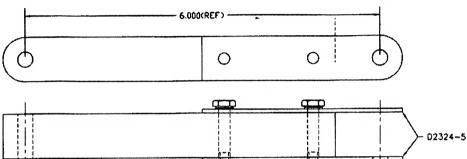
Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM	



DESIGN DRAWN BY DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** DRAWING NO. REV. C CHECKED , APPROVED D2324 SHEET 1 OF 1 SCALE TITLE DATE **STRUT** 04.12.14 94.11.08 NEW ISSUE A UPDATE MATERIALS В 96.05.07 C 04.12.14 UPDATE NOTES

AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1) (TWO PLACES)

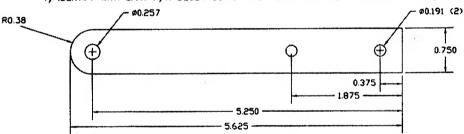
RELEASED 04.12.16



D2324 STRUT ASSEMBLY

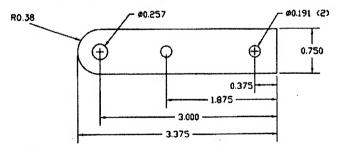
D2324-3

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



## D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
  POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



## D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
  (REF DART SPEC. M304S16GA)
  2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED